

54407 Deren

Work Order ID 53704

November 17, 2009 10:25:46 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09 Start Qty: 10.00

Required Date: 11/30/09 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

*D 22/12/08**HJ for BG 09/12/04*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY *lh*

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R [] Aluminum Rod *m111311*3-Grind End Plate flush *m111494 lh**lh 09-11-30**10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53704

November 17, 2009 10:25:51 AM

Page 2

Item ID: D350-591-311

Accept

Setup Start

Revision ID: B

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09 Start Qty: 10.00

Cust Item ID:

Required Date: 11/30/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.11.30

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 09/11/30

HOLD

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 09.11.30

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53704

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Page 3

Item ID: D350-591-311

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/30/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00

SB 09/12/01



QC

Memo

0.00

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 11/13/11

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53704

November 17, 2009 10:25:57 AM

Page 4

Item ID: D350-591-311

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Revision ID: B

Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09 Start Qty: 10.00

Required Date: 11/30/09 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 09.12.02 (10)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 5012162

(LH x10)

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BL 09-12-2

(LH 10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 53704

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Item ID: D350-591-311

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Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/30/09 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 11/2/48

Memo

0.00

Powder Coating

START TIME: *3:30*
OVEN TEMPERATURE: *320°*
FINISH TIME: *4:00*

64 09-12-2 (10)

PRESSURE WASH

230

Wing Walk as per dwg QSI005 4.4 Batch *M 11/2/23*

0.00



HandFinish

Memo

0.00

Hand Finishing

MD 09/12/03

V10

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/12/03

(V10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53704

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Page 6

Item ID: D350-591-311

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09 Start Qty: 10.00

Required Date: 11/30/09 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>B</u>								

9/12/7

400

=> Sorklos

210
LH

9/12/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53704

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Page 7

Item ID: D350-591-311

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09 Start Qty: 10.00

Required Date: 11/30/09 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/12/09
MF 09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:21 AM

Page 1

Work Order ID: 53704

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09

Required Date: 11/30/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3065-041RevB Manufactured No



Step Leg Assembly Hi

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST 32

53523 32

Main Warehouse

WA 40

52104 40

D3066-1RevB Manufactured No



Spacer

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST 101

51545 14

52662 87

D3219-1RevA Manufactured No



Plate

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST 68

52230 68

120



10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

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10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

10.0000

PTO

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

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11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

11/09.12.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.12.01	180	D3065-0417 belongs to Route Seq. 18. 180 D3066-1 } D3219-1 → belongs to Route Seq 18. 110	He	09.12.01			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:21 AM

Page 2

Work Order ID: 53704

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH



Comments:

Start Date: 11/12/09

Required Date: 11/30/09





Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA		Manufactured	No			110	Each	97.0000	10.0000			
												
End Plate												

12-09-11-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	97	
51546	8	
53451	89	

D3272-1RevB		Manufactured	No			110	Each	0.0000	10.0000			
												
Step												
MS21042LS		Purchased	No			110	Each	926.0000	20.0000			
												

10
12-09-11-19 353761

9/12/11 *SL 100*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	926	
110382	10	
111127	4	
111636	15	
112314	897	

20

November 17, 2009 10:25:21 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:21 AM

Work Order ID: 53704

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH


Comments:

Start Date: 11/12/09

Required Date: 11/30/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No			180	Each	2,015.000	160.0000			
							16					
Rivets												

99-12-01

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2015	
110731	215	
111359	46	
111477	74	
112314	1656	
112385	24	

160

AN3-35A x2

Purchased

No

260

Each

421.0000

20.0000



Bolt

9/12/7 sl 10

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	421	
106993	12	
110467	1	
112314	408	

2051

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:23 AM

Work Order ID: 53704



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09

Required Date: 11/30/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A		Purchased	No			260	Each	299.0000	80.0000			



Bolt



9/12/17 100 S1

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	299	
107321	1	
107534	5	
107959	23	
109285	37	
110552	66	
110865	3	
111477	9	
111925	7	
112314	48	
113149	100	
17406	0	
51764	0	

M113359

8054

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Comments:

Start Date: 11/12/09

Required Date: 11/30/09

Start Qty: 10.00

Required Qty: 10.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-36A <i>x2</i>  Bolt		Purchased	No			260	Each	351.0000	20.0000			

9/12/7 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	351	
109545	11	
110467	7	
110731	4	
112243	20	
<u>112314</u>	259	
112385	50	

2050 

AN960JD10 *x4*



Washer

Purchased

No

260

Each

2,498.000

40.0000

11/10/39 9/12/7 100 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	2498	
105442	19	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
<u>112314</u>	965	
112369	218	
113149	1000	

12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:24 AM

Work Order ID: 53704



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09

Required Date: 11/30/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416	N6	Purchased	No			260	Each	3,603.000	160.0000			



Washer

9/10/17
SL
10

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	3603	
108161	329	
110523	340	
111279	101	
111916	482	
112314	2351	
16941	0	

M103691
M104215

13450

20x
6x8
SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long LH

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Required Date: 11/30/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			260	Each	1,692.000	40.0000			



Washer



9/12/11

100

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1692	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	64	
112314	282	
112828	500	
113149	500	

408

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:25 AM

Work Order ID: 53704

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Comments:

Start Date: 11/12/09

Required Date: 11/30/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-3RevG

74

Manufactured

No

260

Each

169.0000

40.0000

33x

353430 9/12/17 sl



HD Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

51568

3

Main Warehouse

ST176

166

51428

166

15d

6x5d

D2618RevB1

72

Manufactured

No

260

Each

251.0000

20.0000

9/12/17

100 sl



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST39

251

50989

200

51189

51

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:40 AM

Work Order ID: 53704

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Comments:

Start Date: 11/12/09

Required Date: 11/30/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2856-400RevA	x2 @ 720"	Manufactured	No			260	f	360.0237	6.0000			
---------------	-----------	--------------	----	--	--	-----	---	----------	--------	--	--	--



Abraison Strip

9/12/17 SL

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST403

360.0236842

50593

144.023684

52563

216

D3067-1RevA

Manufactured No



End Plate

260 Each 97.0000 10.0000



09-12-01

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

97

51546

8

53451

89

D3235-1RevA

Manufactured No



Mounting Lug

260 Each 93.0000 20.0000



9/12/17 10x50

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

93

45398

4

47969

89

1050

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 17, 2009 10:25:40 AM

Work Order ID: 53704

Parent Item: D350-591-311RevB

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09

Required Date: 11/30/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3278-041RevC

fl

Manufactured

No

260

Each

73.0000

10.0000



Support Assembly

9/12/17

sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

73

52075

73

MS21042L3

fl

Purchased

No

260

Each

3,038.000

20.0000



Nut

1050

9/12/17

sf

100

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3038

110844

32

111274

27

111668

487

112314

1992

112385

500

M109798

14x

6x

x 14x 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

November 17, 2009 10:25:46 AM

Work Order ID: 53704



Parent Item: D350-591-311RevB



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 11/12/09

Required Date: 11/30/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			260	Each	5,129.000	80.0000			



S
Nut



9/12/1

100

SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5129	
110507	184	
111827	4938	
112314	7	
15924	0	

8050

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04-*ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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WORK ORDER

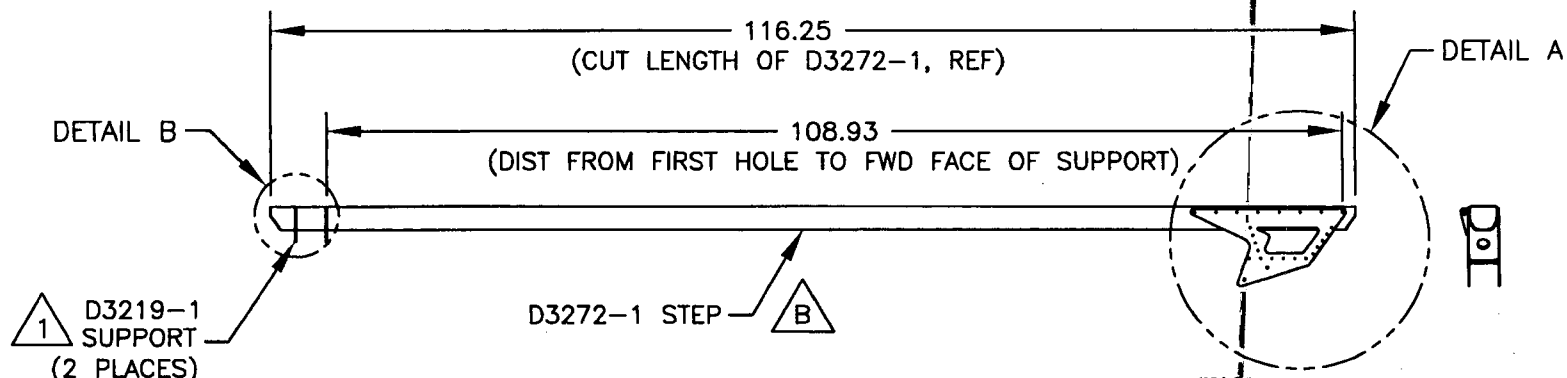
NO. *53024* *537041*
07-10-22

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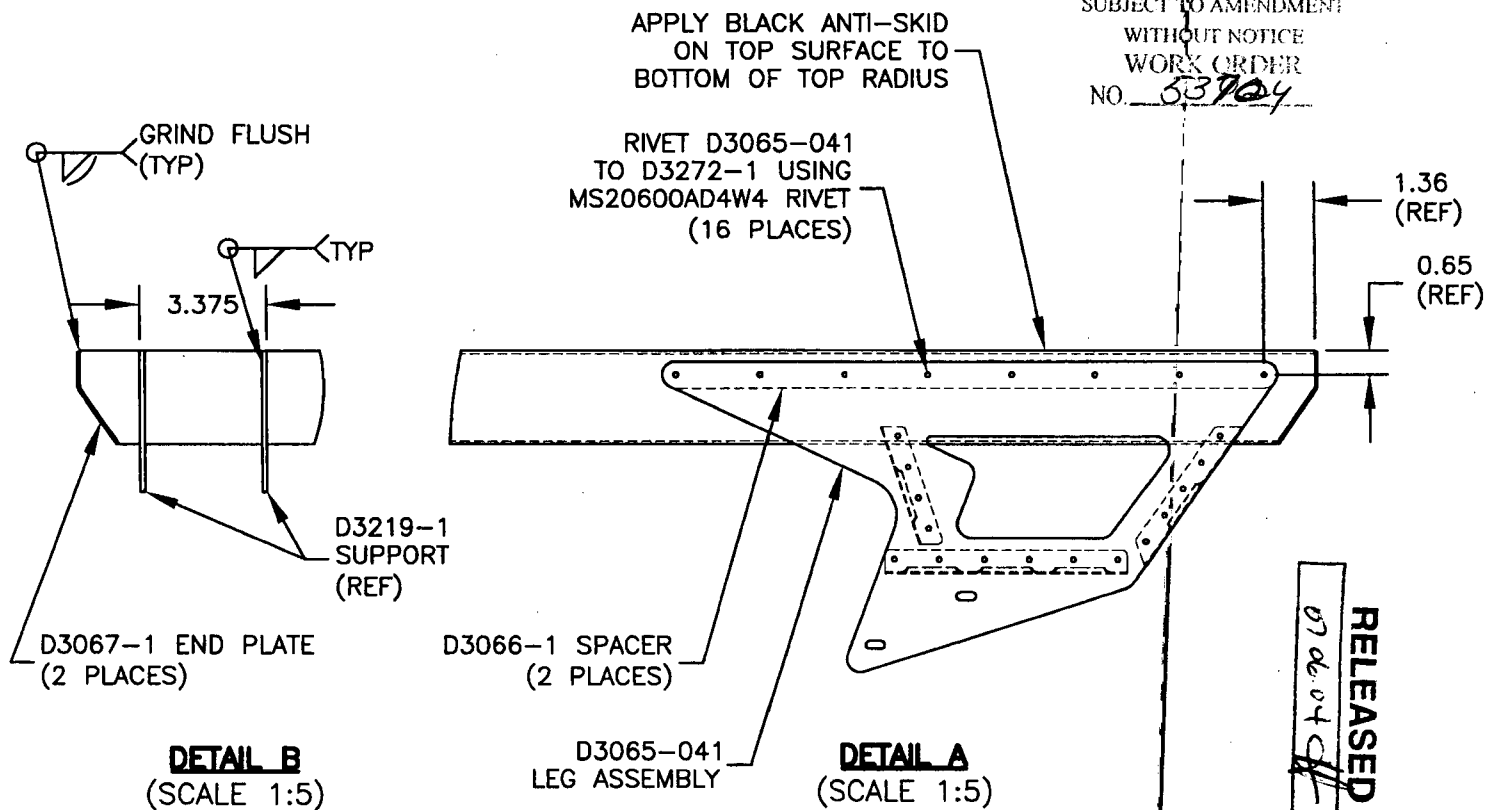
DART

DESIGN	40	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	MR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		DRAWING NO.	D3272	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

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 NO. 53704



DART

DESIGN	49	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 3 OF 3
		SCALE	1:20	

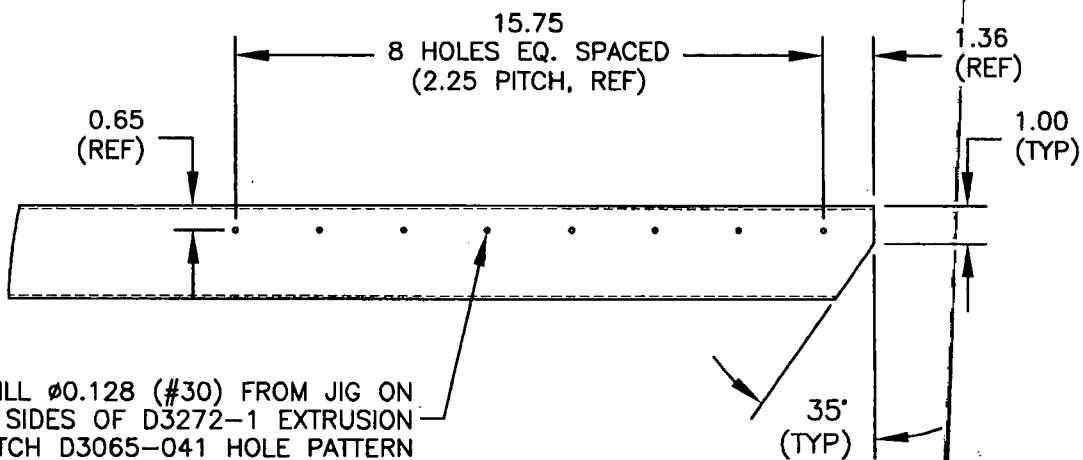
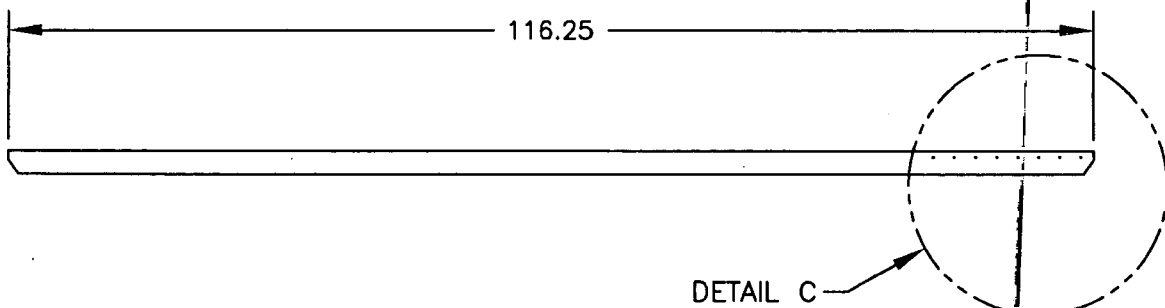
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07.06.04

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WORK CENTER
NO. 53704

DETAIL C

D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

54407